



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D135-1027-253**  
**Job Sheet 169671**



Part No: D135-1027-253

Job Qty: 1 ea

Part Name: Mid Height Aft Crosstube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/18/17

Job Tracking No:

Due Date: 1/11/18

Created By: Diane Baker

Type: Stock

Description:

Note: TBD DWG REV A IPP REV:A 17.01.24 NEW ISSUE DD VERF:JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation  | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |            |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 110   | Purchasing | 1 pcs | 1/11/18    | 1/11/18  | 0.00      | 0.00    | Purchasing            |           | JAN 22 2018 |
| 120   | Packaging  | 1 pcs | 1/11/18    | 1/11/18  | 0.00      | 0.00    | Packaging2            |           | JAN 22 2018 |
| 130   | QC         | 1 pcs | 1/11/18    | 1/11/18  | 0.00      | 0.00    | QC15                  |           | 13-3-22     |
| 140   | Outsource  | 1 pcs | 1/11/18    | 1/11/18  | 0.00      | 0.00    | Outsource2            |           | AT 18/04/25 |
| 150   | Packaging  | 1 pcs | 1/11/18    | 1/11/18  | 0.00      | 0.00    | Packaging2            |           | AT 18/04/25 |
| 160   | QC         | 1 pcs | 1/11/18    | 1/11/18  | 0.00      | 0.00    | QC5                   |           | 38          |
| 170   | Packaging  | 1 pcs | 1/11/18    | 1/11/18  | 0.00      | 0.00    | Packaging3-1          | LG050     | APR 09 2018 |
| 180   | QC21-FG    | 1 Ea  | 1/11/18    | 1/11/18  | 0.00      | 0.00    | QC21                  |           | 21          |

Part Op 110 - Issue P/O to Tube Caron: 03879 Manufacture D135-1027-253 as per dwg (Bend, Remove Excess  
Descriptions: material after bending, Drill ) \*\*Ship extrusion D6027-115\*\* \*\*\*AS PER DWG NOTE 10, EXTREME CARE MUST BE  
TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND  
FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.\*\*\* Material release note is required  
120 - Ensure material release note is attached  
140 - ISSUE P/O: 039676 C OF C IS REQUIRED  
150 - C OF C IS REQUIRED

### Job Allocations

| Operation      | Component Part                | Required | Inventory | Allocated | Std Qty |
|----------------|-------------------------------|----------|-----------|-----------|---------|
| 110-Purchasing | D135-1027-253P <u>5034182</u> | 1        | 0         | 0         | 0       |
|                | D6027-115                     | 1        | 4         | 0         | 0       |

### Part Specifications

Specifications could not be found.



**Dart Aerospace Ltd.**

1270 Aberdeen Street  
Hawkesbury, ON K64 1K7  
CANADA

TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

**Container No: S053471**



**Mid Height Aft Crosstube**

**PART NO: D135 – 1027 – 253**

**Serial No/Batch: S053471**

**Revision:**

**Operation: Packaging**

**Change No:**

**Mfg Date: 03/21/18**

**Job No: 169671**

100 5 5 1000  
100 5 5 1000  
100 5 5 1000

|                                              |  |                     |                      |
|----------------------------------------------|--|---------------------|----------------------|
| <b>DART AEROSPACE LTD</b>                    |  | <b>Work Order:</b>  |                      |
| <b>Description: MID HEIGHT AFT CROSSTUBE</b> |  | <b>Part Number:</b> | <b>D135-1027-253</b> |
| <b>Inspection Dwg: D135-1027-253 Rev: B</b>  |  | <b>Page 1 of 2</b>  |                      |

### INSPECTION SHEET

| Drawing Dimension | Tolerance          | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|--------------------|------------------|--------|--------|----------------------|----------|
| 3.550" TYP        | +/-0.005"          | 3.550"           |        |        |                      |          |
| 8.23" TYP         | +/-0.030"          | 8.250"           |        |        |                      |          |
| 12.08" TYP        | +/-0.030"          | 12.100"          |        |        |                      |          |
| 2.19" REF         | +/-0.030"          |                  |        |        |                      |          |
| 3.13" TYP         | +/-0.030"          | 3.120"           |        |        |                      |          |
| Ø.194" THUR 2PL   | +0.006"<br>-0.001" | .190"            |        |        |                      |          |
| Ø.194" THUR       | +0.006"<br>-0.001" | .190"            |        |        |                      |          |
| 17.0" 2PL         | +/-0.100"          | 17"              |        |        |                      |          |
| Ø.313" THUR 6PL   | +0.006"<br>-0.001" | .312"            |        |        |                      |          |
|                   |                    |                  |        |        |                      |          |
|                   |                    |                  |        |        |                      |          |
| Ø.670" THUR 2PL   | +0.006"<br>-0.001" | .670"            |        |        |                      |          |
|                   |                    |                  |        |        |                      |          |

### WALL THICKNESS MEASUREMENTS

| LOCATION FROM CL | DWG DIM | R1 | R2 | R3 | R4 |  |  |  |  |
|------------------|---------|----|----|----|----|--|--|--|--|
| CL               | 0.197"  |    |    |    |    |  |  |  |  |
| 21"              | 0.197"  |    |    |    |    |  |  |  |  |
| 21"              | 0.197"  |    |    |    |    |  |  |  |  |
| CENTER OF BEND   | 0.197"  |    |    |    |    |  |  |  |  |
| CENTER OF BEND   | 0.197"  |    |    |    |    |  |  |  |  |

### OUTSIDE DIAMETER MEASUREMENTS

| LOCATION       | DWG DIM | M1    | M2    |  |  |  |  |
|----------------|---------|-------|-------|--|--|--|--|
| CL             | 3.543"  | 3.545 | 3.550 |  |  |  |  |
| CENTER OF BEND | 3.543"  | 3.536 | 3.520 |  |  |  |  |
| CENTER OF BEND | 3.543"  | 3.533 | 3.523 |  |  |  |  |

### CRUSHING

|        | SIDE A | SIDE B |
|--------|--------|--------|
| MAX 2% | .32    | .21    |

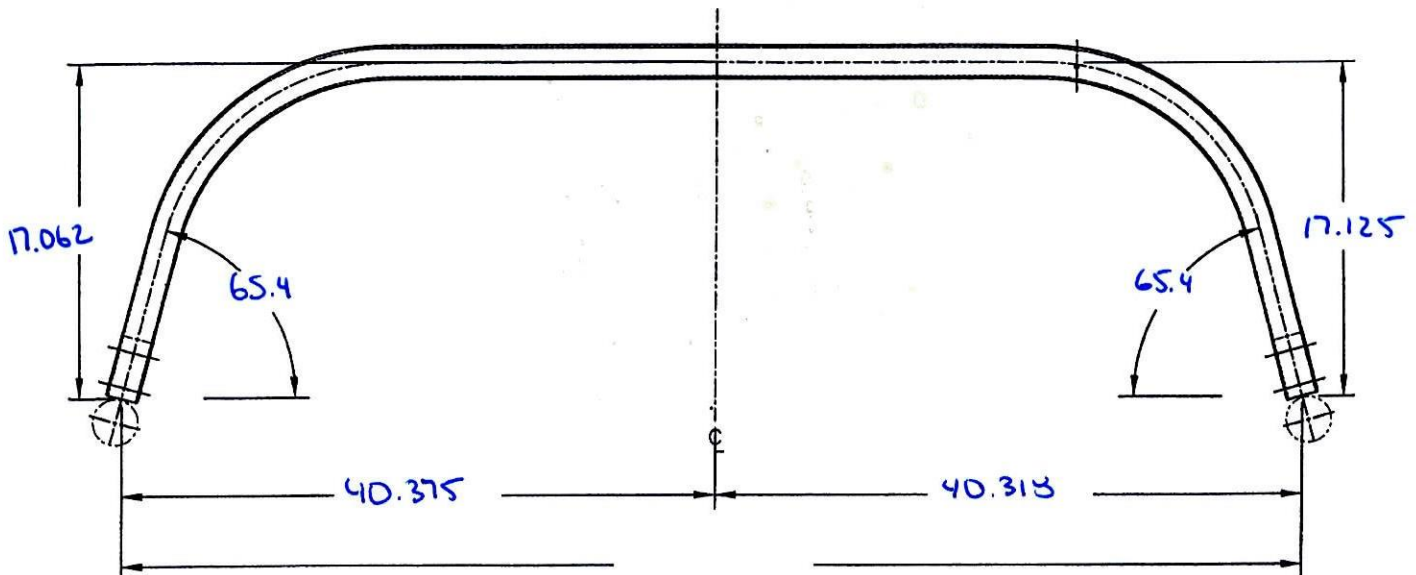
### TWIST

|           | SIDE A | SIDE B |
|-----------|--------|--------|
| MAX 0.25" |        |        |



|                                                    |  |                     |               |
|----------------------------------------------------|--|---------------------|---------------|
| <b>DART AEROSPACE LTD</b>                          |  | <b>Work Order:</b>  |               |
| <b>Description:</b> MID HEIGHT AFT CROSSTUBE       |  | <b>Part Number:</b> | D135-1027-253 |
| <b>Inspection Dwg:</b> D135-1027-253 <b>Rev:</b> B |  | <b>Page 2 of 2</b>  |               |

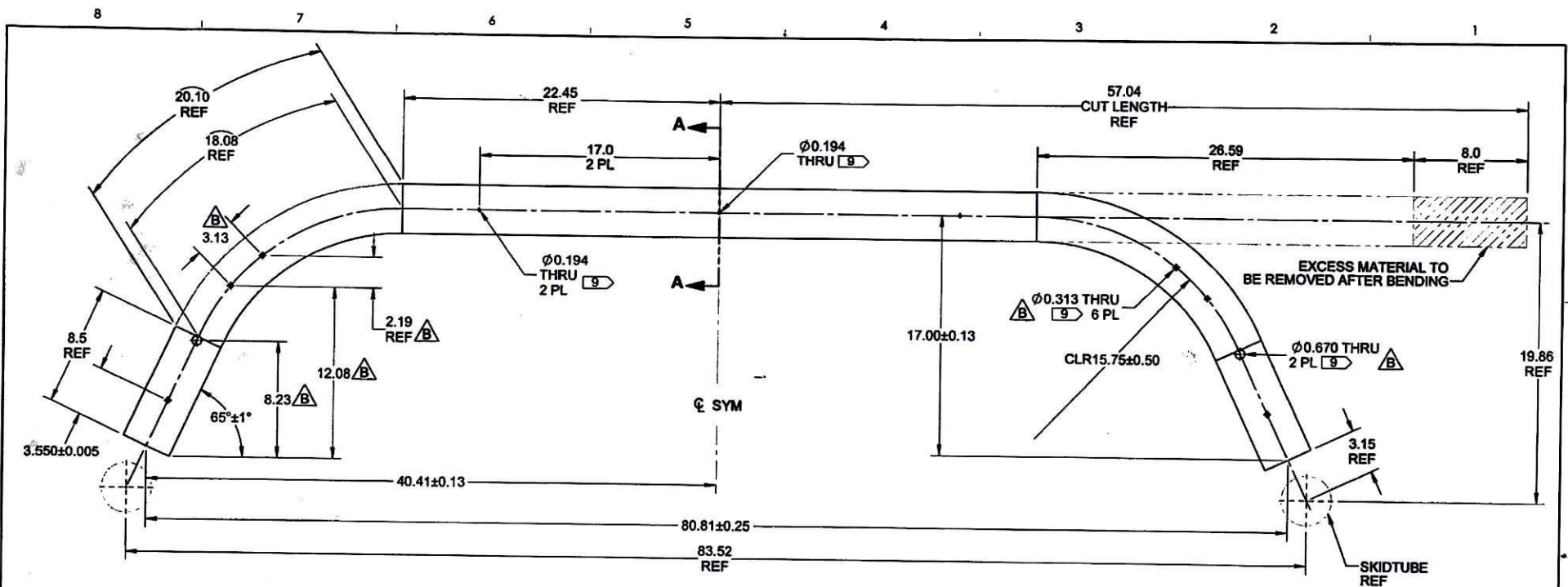
| Required Dimension | Min    | Max    |
|--------------------|--------|--------|
| Height             | 16.87" | 17.13" |
| 1/2 Span           | 40.28" | 40.54" |
| Angle              | 64°    | 66°    |
| Total Span         | 80.56" | 81.08" |
| Bending Passes     |        |        |
| Crushing           | 0%     | 2%     |
| Twist              | 0.0"   | 0.25"  |



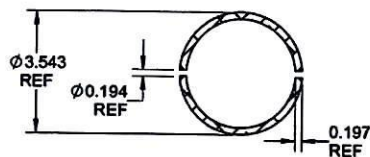
|                     |  |                    |  |                      |  |
|---------------------|--|--------------------|--|----------------------|--|
| <b>Measured by:</b> |  | <b>Checked by:</b> |  | <b>QC Inspector:</b> |  |
| <b>Date:</b>        |  | <b>Date:</b>       |  | <b>Date:</b>         |  |

|                                                |  |              |  |
|------------------------------------------------|--|--------------|--|
| <b>Engineering Approval:</b><br>(If necessary) |  | <b>Date:</b> |  |
|------------------------------------------------|--|--------------|--|

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 18/01/16 | New Issue | ED         |          |



### D135-1027-253 MID HEIGHT AFT CROSSTUBE



SECTION A-A  
SCALE 2X

RELEASED  
2017-08-01  
SCN 17-607

#### NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6027-115  
STRAIGHT LENGTH = 114.08±0.06 (BEFORE BENDING / TRIMMING)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 20.57 lbs
- 8) MAX TWIST: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE SHALL BE NO LARGER THAN 0.25.
- 9) HOLES TO BE ALIGNED WITHIN 0.005 IN RELATION TO THE HOLE ON OPPOSITE SIDE OF CROSSTUBE.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038. TO BE PERFORMED AFTER FINAL POST-BEND GRINDING. ANY ADDITIONAL GRINDING REQUIRES ANOTHER LPI INSPECTION.
- 12) MAXIMUM TUBE FLATTENING DUE TO BENDING IS 2% BASED ON OD.

|            |          |                                                                                  |    |          |
|------------|----------|----------------------------------------------------------------------------------|----|----------|
| DESIGN     | ML       | ADD QTY (2) Ø 0.313 HOLES, 3.13 WAS 3.15, 12.08 WAS 12.04. REASON: DESIGN CHANGE | ML | 17.05.25 |
| DRAWN      | ML       | NEW ISSUE                                                                        | ML | 17.01.31 |
| CHECKED    | NO       | DESCRIPTION                                                                      | BY | DATE     |
| MFG. APPR. | DD       |                                                                                  |    |          |
| APPROVED   | WM       |                                                                                  |    |          |
| DE APPR.   | CP       |                                                                                  |    |          |
| DATE       | 17.05.25 |                                                                                  |    |          |

|                             |              |
|-----------------------------|--------------|
| DART AEROSPACE LTD          |              |
| HAWKESBURY, ONTARIO, CANADA |              |
| DRAWING NO.                 | REV. B       |
| D135-1027-253               | SHEET 1 OF 1 |
| TITLE                       | SCALE        |
| MID HEIGHT AFT XTUBE        | NTS          |

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**SHIPPING BILL****BOL 12425**  
**16/01/2018****Tube Caron Inc.**99 Louis-Joseph-Doucet  
Lanoraie, QC, Canada  
J0K 1E0  
Phone: 450-887-2766

Fax: 450-887-2897

**Ship To:**Dart Aerospace Ltd  
1270 Aberdeen Street  
Hawkesbury, ON, Canada  
K6A 1K7

Phone : 613-632-1053

Fax : 613-632-4443

**Sold To:**Dart Aerospace Ltd  
1270 Aberdeen Street  
Hawkesbury, ON, Canada  
K6A 1K7  
Phone : 613-632-5200

Fax : 613-632-4443

**Third Party Billing:**

| Ln | Item                | Qty | Po       | Job      | Weight | UOM    |
|----|---------------------|-----|----------|----------|--------|--------|
| 1  | PALETTE             | 1   |          |          | 20.00  | Pounds |
|    | BOITE COMBO         | 1   |          |          | 13.00  | Pounds |
|    | D135-1027-153 REV B | 2   | PO038679 | J17875-2 | 29.14  | Pounds |
|    | D135-1027-253 REV B | 4   | PO038679 | J17875-1 | 79.24  | Pounds |

**JAN 22 2018****Carrier:****Phone:****Way Bill:**Journey Freight  
1-888-633-1252 #3221**Fob:****Freight Charges:**Fob Lanoraie  
Collect**Total Of Packages :**

Carrier : Journey Freight

1 SKID  
48 X 40 X 91**Total Weight:**

141.38 #

Shipper : Tube Caron Inc.

Declared Value :

(No Additional Insurance Required)

Not Applicable For Insurance Purposes

16-01-2018





Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER PO038679

**Supplier:** TUB001-VC  
Tube Caron Inc.  
99 Louis-Joseph-Doucet Street  
Lanoraie  
QC  
JOK 1EO Canada  
Phone: 450-887-2766  
Fax: 450-887-2897

**PO No:** PO038679  
**PO Date:** 12/18/17  
**Due Date:** 1/12/18  
**Purchase Order  
Revision:**  
**Revision Date:**  
**Ship-To Contact:** Phone:

DEC 19 2017

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Via:** Ground  
**Pymt Terms:** Net 30  
**Freight Terms:**  
**Special Comments:**

| Items                                   |                |                  |                                                                |        |          |                |                   |         |                  |                |  |
|-----------------------------------------|----------------|------------------|----------------------------------------------------------------|--------|----------|----------------|-------------------|---------|------------------|----------------|--|
| Line Item                               | Part           | Supplier Part No | Description                                                    | Status | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price |  |
| 1                                       | D135-1027-253P |                  | Mid Height Aft Crosstube<br>As Per Dwg D135-1027-253<br>Rev. B | Firmed | 1/12/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$600.00/pcs     | \$600.00       |  |
| Line Item Note job# 169662 - Priority 1 |                |                  |                                                                |        |          |                |                   |         |                  |                |  |
| 2                                       | D135-1027-253P |                  | Mid Height Aft Crosstube<br>As Per Dwg D135-1027-253<br>Rev. B | Firmed | 1/12/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$600.00/pcs     | \$600.00       |  |
| Line Item Note job# 169670 - Priority 1 |                |                  |                                                                |        |          |                |                   |         |                  |                |  |
| 3                                       | D135-1027-253P |                  | Mid Height Aft Crosstube<br>As Per Dwg D135-1027-253<br>Rev. B | Firmed | 1/12/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$600.00/pcs     | \$600.00       |  |
| Line Item Note job# 169671 - Priority 1 |                |                  |                                                                |        |          |                |                   |         |                  |                |  |
| 4                                       | D135-1027-253P |                  | Mid Height Aft Crosstube<br>As Per Dwg D135-1027-253<br>Rev. B | Firmed | 1/12/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$600.00/pcs     | \$600.00       |  |
| Line Item Note job# 169672 - Priority 1 |                |                  |                                                                |        |          |                |                   |         |                  |                |  |
| 5                                       | D135-1027-251P |                  | Std Height Aft Crosstube<br>As Per Dwg D135-1027-251<br>Rev. C | Firmed | 1/12/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$600.00/pcs     | \$600.00       |  |
| Line Item Note job# 169663 - Priority 2 |                |                  |                                                                |        |          |                |                   |         |                  |                |  |
| 6                                       | D135-1027-251P |                  | Std Height Aft Crosstube<br>As Per Dwg D135-1027-251<br>Rev. C | Firmed | 1/12/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$600.00/pcs     | \$600.00       |  |
| Line Item Note job# 169675 - Priority 2 |                |                  |                                                                |        |          |                |                   |         |                  |                |  |
| 7                                       | D135-1027-251P |                  | Std Height Aft Crosstube<br>As Per Dwg D135-1027-251<br>Rev. C | Firmed | 1/12/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$600.00/pcs     | \$600.00       |  |
| Line Item Note Job# 169673 - Priority 2 |                |                  |                                                                |        |          |                |                   |         |                  |                |  |
| 8                                       | D135-1027-251P |                  | Std Height Aft Crosstube<br>As Per Dwg D135-1027-251<br>Rev. C | Firmed | 1/12/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$600.00/pcs     | \$600.00       |  |
| Line Item Note job# 169674 - Priority 2 |                |                  |                                                                |        |          |                |                   |         |                  |                |  |
| 9                                       |                |                  |                                                                | Firmed | 1/12/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$600.00/pcs     | \$600.00       |  |

## CERTIFICATE OF CONFORMANCE

**CUSTOMER :** Dart Aerospace

**DATE :** January 16, 2018

**P.O.#** PO038679

I certify that the following parts were manufactured to the specifications stated on the drawings listed below.

Note: Material for manufacturing of parts is provided by Dart Aerospace.

| PART NO.                              | QTY. | DRAWING NO. / REV.    |
|---------------------------------------|------|-----------------------|
| D135-1027-253<br>MID HEIGHT AFT XTUBE | 4    | D135-1027-253 / REV.B |
| D135-1027-153<br>MID HEIGHT FWD XTUBE | 2    | D135-1027-153 / REV.B |

Note: 1) 2x D135-1027-153 were manufactured instead of the 4 requested on PO038679 due to the limited extrusions available. This information was communicated to Robert Aboud.

2) Center hole of Ø0.194" on one of the D135-1027-253 parts has a small defect that was accepted by Eric Downing.

Sincerely,



Michael Plante





Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# **PURCHASE ORDER** **PO039676**

**Supplier:** SKY002-VC  
Skyservice  
6120 Midfield Road  
Mississauga  
ON  
L5P 1B1 Canada  
Phone: 905-678-5636  
Fax: 905-678-5841

**PO No:** PO039676  
**PO Date:** 4/23/18  
**Due Date:**  
**Purchase Order**  
**Revision:**  
**Revision Date:**  
**Ship-To Contact:** Phone:

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Via:** Ground  
**Pymt Terms:** Net 30  
**Freight Terms:**  
**Special Comments:**

## Items

| Line Item         | Job    | Part          | Description                                                        | Status | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price  |
|-------------------|--------|---------------|--------------------------------------------------------------------|--------|----------|----------------|-------------------|---------|------------------|-----------------|
| 1                 | 169678 | D135-1027-153 | Mid Height Fwd Crosstube<br>ISSUE P/O: _____ C OF<br>C IS REQUIRED | Firmed |          | 1 pcs          | 0 pcs             | 1 pcs   | \$167.00/pcs     | \$167.00        |
|                   | 169677 |               |                                                                    | Firmed |          | 1 pcs          | 0 pcs             | 1 pcs   | \$167.00/pcs     | \$167.00        |
| <b>Sub Total:</b> |        |               |                                                                    |        |          | 2              | 0                 | 2       |                  | <b>\$334.00</b> |

|                   |        |               |                                                                    |        |  |       |       |       |              |                 |
|-------------------|--------|---------------|--------------------------------------------------------------------|--------|--|-------|-------|-------|--------------|-----------------|
| 2                 | 169671 | D135-1027-253 | Mid Height Aft Crosstube<br>ISSUE P/O: _____ C OF<br>C IS REQUIRED | Firmed |  | 1 pcs | 0 pcs | 1 pcs | \$167.00/pcs | \$167.00        |
|                   | 169670 |               |                                                                    | Firmed |  | 1 pcs | 0 pcs | 1 pcs | \$167.00/pcs | \$167.00        |
|                   | 176211 |               |                                                                    | Firmed |  | 1 pcs | 0 pcs | 1 pcs | \$167.00/pcs | \$167.00        |
| <b>Sub Total:</b> |        |               |                                                                    |        |  | 3     | 0     | 3     |              | <b>\$501.00</b> |

**Grand Total:** **\$835.00**

## Order Notes

*rec'd AT 18/4/18*

### Procurement Quality Clauses

A005 right of entry  
A012 chemical and physical test report  
A016 personnel qualification  
A017 raw material identification (as applicable)

A022 Apical Processing  
A024 process certifications  
A026 certification of material conformance

A041 quality management system  
A042 dart notification by supplier  
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.



# skyservice Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

|                          |                               |               |                    |
|--------------------------|-------------------------------|---------------|--------------------|
| WO #: MWO35758           | Customer: Dart Aerospace Ltd. | Dept: NDT YUL | Reference: PO39676 |
| Descr:                   | PN:                           | S/N:          | Qty: 1             |
| Make:                    | Model:                        | Reg:          | A/C S/N:           |
| TSN:                     | CSN:                          | TSO:          |                    |
| Task: <b>UNSCHEDULED</b> |                               |               | Sequence: 1        |

## Work Required:

CARRY OUT LIQUID PENETRANT INSPECTION ON FIVE MID HEIGHT AFT CROSSTUBES P/N : D135-1027-253 AS PER PO : PO39676

- 1 - JOB SHEET : 176211 2 - JOB SHEET : 169678  
3 - JOB SHEET : 169677 4 - JOB SHEET : 169671  
5 - JOB SHEET : 169670

| Action Taken:                                                                                                                                                               | Date:       | Initial/Stamp:                             |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|--------------------------------------------|
| <p>LIQUID PENETRANT INSPECTION CARRIED OUT AS PER ASTM E-1417M-13</p> <p>NO CRACK FOUND</p> <p>PEN. ZL-56, MPO13600, UV M-20141, CLEANER SKC-S MPO13923 , DEV. MPO11715</p> | APR 23 2018 | <p>LM</p> <p>DOT-APP<br/>278<br/>53-89</p> |

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

|                              |                         |             |
|------------------------------|-------------------------|-------------|
| Signature:                   | ACA/SCA Stamp           | Date:       |
| Name: <b>LUIGI MARCHETTI</b> | DOT-APP<br>278<br>53-89 | APR 23 2018 |